

Work Order ID 50584

July 16, 2009 8:57:56 AM

Page 1

Item ID: D3138-2 *GY*

Revision ID: C

Item Name: Cover

Start Date: 7/17/09

Start Qty: 2.00

Required Date: 7/24/09

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3138

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3138

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> ml 09 07 16 (2)

=> ml 09 07 16 (2)

=> 8 09/07/12

(+2)

4

Work Order ID 50584

July 16, 2009 8:57:56 AM

Page 2

Item ID: D3138-2

Revision ID: C

Item Name: Cover

Start Date: 7/17/09 Start Qty: 2.00

Required Date: 7/24/09 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr

Bend as per Dwg D3138

0.00

0.00

Deburr m. h. 09/07/17 (2x)
JB Ge 10/7/20 (2)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 802/760 (2) 4

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

WMO 09/07/20 (x2)

Work Order ID 50584

July 16, 2009 8:57:56 AM



Page 3

Item ID: D3138-2

Accept



Setup Start



Revision ID: C

Stop



Item Name: Cover

Start Date: 7/17/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



M 109091

Powdercoat

Memo

0.00

Powder Coating

START TIME: *7:45*

OVEN TEMPERATURE: *320*

FINISH TIME: *8:15*

BL 02-07-22 (2)

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 5 or less 122

(+2) f

180

Identify as per dwg & Stock Location: *241A*

0.00



Packaging

Memo

0.00

Packaging

9/17/22 (2x) SF

Work Order ID 50584

July 16, 2009 8:57:56 AM



Page 4

Item ID: D3138-2

Accept



Setup Start



Revision ID: C

Stop



Item Name: Cover

Start Date: 7/17/09

Start Qty: 2.00



Cust Item ID:

Required Date: 7/24/09

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/23 *[Signature]*
MF 09-07-23

Picklist Print

July 16, 2009 8:57:56 AM

Work Order ID: 50584



Parent Item: D3138-2RevC



Parent Item Name: Cover

Start Date: 7/17/09

Required Date: 7/24/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No				sf	111.0100	3.8794			



2024-T3 .032 sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

111.01

102942

1.5

105555

5

106272

8.47

108595

3

109240

7.02

110778

34.02

111699

49

18147

3

M 09 07 16

DART AEROSPACE LTD	Work Order: 50584
Description: COVER	Part Number: D3138-2
Inspection Dwg: D3138 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

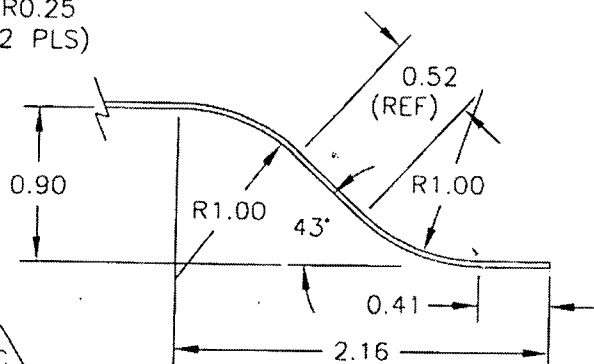
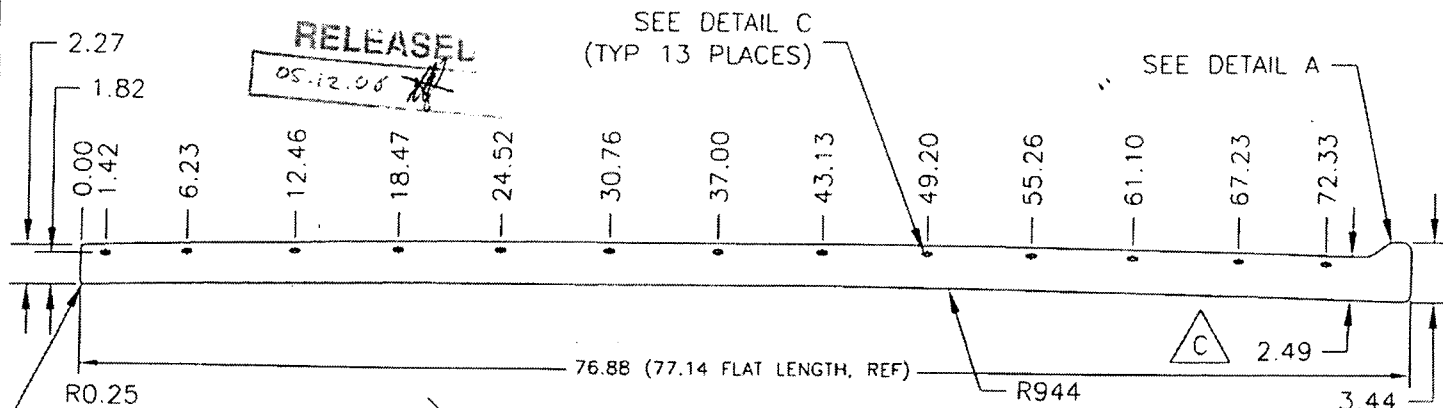
<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
-------------------------------------	----------------------	--------------------------	------------------

[illegible]

Measured by:	M. Nat	Audited by:	S	Prototype Approval:	A
Date:	09-07-16	Date:	09/07/17	Date:	A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

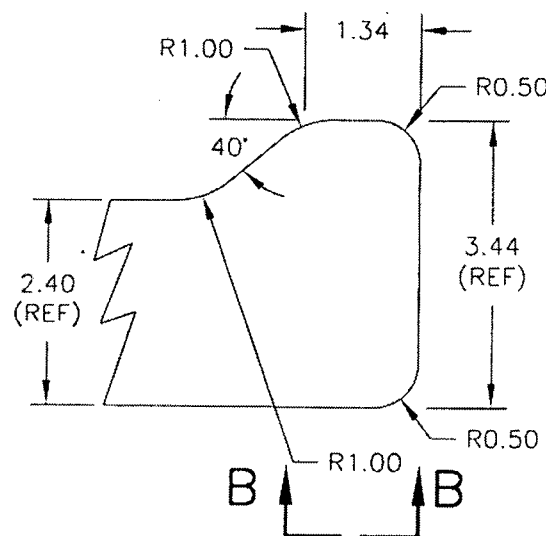
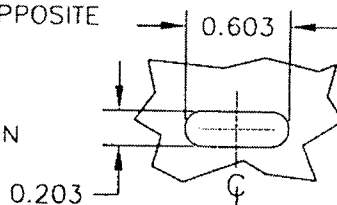
DART



VIEW B-B

BEND D3138-1 AS SHOWN
BEND D3138-2 OPPOSITE
SCALE 1:1

DETAIL C
LOCATION DIMENSION
TO CENTERLINE
SCALE 1:1



DETAIL A
FLAT PATTERN SHOWN
SCALE 1:2

DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.12.05	TITLE	D3138	REV. C
		COVER		SHEET 1 OF 1
				SCALE 1:10
A	02.04.18	NEW ISSUE		
B	04.09.20	RE-DESIGN		
C	05.12.05	CORRECT VIEW B-B; ADD 2.49 DIM.		

D3138-1 COVER (SHOWN. REPLACES PREMIER P/N B30-23000-205)

D3138-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-206)

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2002 by DART AEROSPACE LTD